

Date: Thursday, 20/11/2008 3:11:23 PM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	LH ACTUATOR ASSEMBLY
Job Number :	43569		
Estimate Number :	12761		
P.O. Number :		Part Number :	41232 200 001 001
This Issue :	20/11/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	41232-200-001 REV IR
First Issue :	//	Project Number :	N/A
Previous Run :	43286	Drawing Revision :	IR
	Type :	Material :	
	SMALL /MED FAB	Due Date :	28/12/2008
Written By :		Qty:	2 Um: Each
Checked & Approved By :	JLD 08-11-21		
Comment :	Est Rev:A New Issue 07-02-28 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MS208224	elbow
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

elbow

Batch: M110363

9/5/21

SC

2.0	AN8424D	Elbow
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Elbow

Batch: M16139

9/5/21

SC

3.0	41232 200 007 001	Brass Cylinder Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Brass Cylinder Assembly

Batch: 43733

6/9/19

4.0	MS1699623	cap screw
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

cap screw

Batch: M103934

9/5/21

SC

5.0	AN3154R	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M17566

9/5/21

SC

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN960JD416	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M111279

9/5/21

SP

7.0	AN960JD10	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M111279

9/5/21

SP

8.0	MS21042L3	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M110844

9/5/21

SP

9.0	AN322A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M106043

9/5/21

SP

10.0	41232 200 005 003	Spacer (Step Actuator)
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer (Step Actuator)

Batch: 1239218

9/5/21

SP

11.0	41232 200 002 005	pivot arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

pivot arm

Batch: B46701

9/5/21

SP

12.0	41232 200 002 003	latch
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

latch

Batch: 46703

9/5/21

(24)

SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Drawing Name: LH ACTUATOR ASSEMBLY

Job Number: 43569

Part Number: 41232 200 001 001

Job Number:



Seq. #: Machine Or Operation: Description :

13.0 41232 200 002 001 tube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
tube
Batch: 43303

9/15/21

SP

14.0 41232 200 008 001 Decal



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Decal
Batch: 43303 B46687

~~9/15/21~~ 12/8/12

15.0 S 1455 spring-step actuator (replaces 71459)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
spring-step actuator (replaces 71459)
BATCH: 1110154

9/15/21

(24)
26

16.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1- Assemble as per Dwg 41232-200-001
2-Torque as per Dwg 41232-200-001

FF- 09-06-15 (2)

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/29/06/05

(24)
24

18.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:

9/16/16

SP

19.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/16

Job Completion



MF 09-06-16

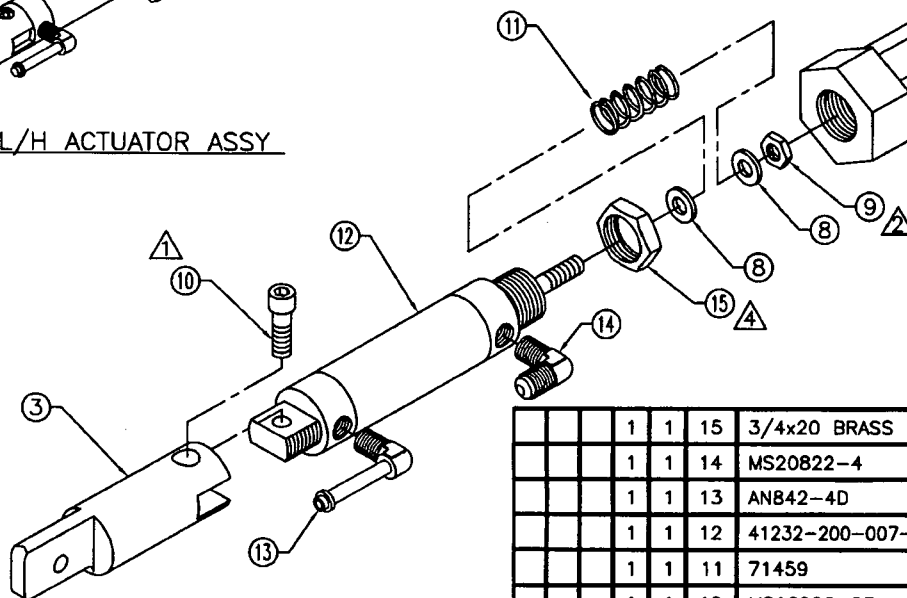
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

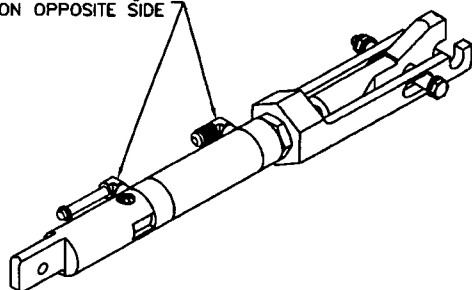
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



INSTALL ITEM #12
ON OPPOSITE SIDE



-002 R/H ACTUATOR ASS

-  4 TORQUE 80-100 IN.-LB.
 3 TORQUE 20-25 IN.-LB.
 2 TORQUE 50-75 IN.-LB.
 1 TORQUE 50-75 IN.-LB.

NOTES:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
80433109

			1	1	15	3/4x20 BRASS	CYLINDER NUT								
			1	1	14	MS20822-4	ELBOW								
			1	1	13	ANB42-4D	ELBOW								
			1	1	12	41232-200-007-001	CYLINDER								
			1	1	11	71459	SPRING								
			1	1	10	MS16996-23	CAP SCREW								
			1	1	9	AN315-4R	NUT								
			2	2	8	AN960JD416	WASHER								
			2	2	7	AN960JD10	WASHER								
			1	1	6	MS21042-L3	NUT								
			1	1	5	AN3-22A	BOLT								
			2	2	4	41232-200-005-003	SPACER								
			1	1	3	41232-200-002-005	PIVOT ARM								
			1	1	2	41232-200-002-003	LATCH								
			1	1	1	41232-200-002-001	TUBE								
						-002	R/H ACTUATOR ASSY								
						-001	L/H ACTUATOR ASSY								
			-002	-001	FND NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE				
LIST OF MATERIAL															
NO. REQ'D PER ASSY			UNLESS OTHERWISE SPECIFIED				DRAFTSMAN	D. NELSON	5/20/02	TITLE					
PROPRIETARY RIGHTS NOTICE			X±.1				CHECK	D. MURPHY	5/20/02	STEP ACTUATOR ASSY					
THESE DATA ARE PROPRIETARY TO ERN AVIATION, INC. DISCLOSURE, REPRODUCTION, OR USE OF THESE DATA FOR ANY PURPOSE IS PROHIBITED WITHOUT WRITTEN AUTHORIZATION FROM ERN AVIATION, INC. THE FOLLOWING DOES NOT APPLY TO VENDOR PARTS.			XOL ±.03				STRESS			DWG. SIZE		C	SCALE		
			XOOL ±.010				PROD ENGR						NONE		
			ANGLES ±.1°				HEAT TREAT						DWG. NO.		
							FINISH						41232-200-001		
							Ern Aviation, Inc.				REV				
											IF				

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